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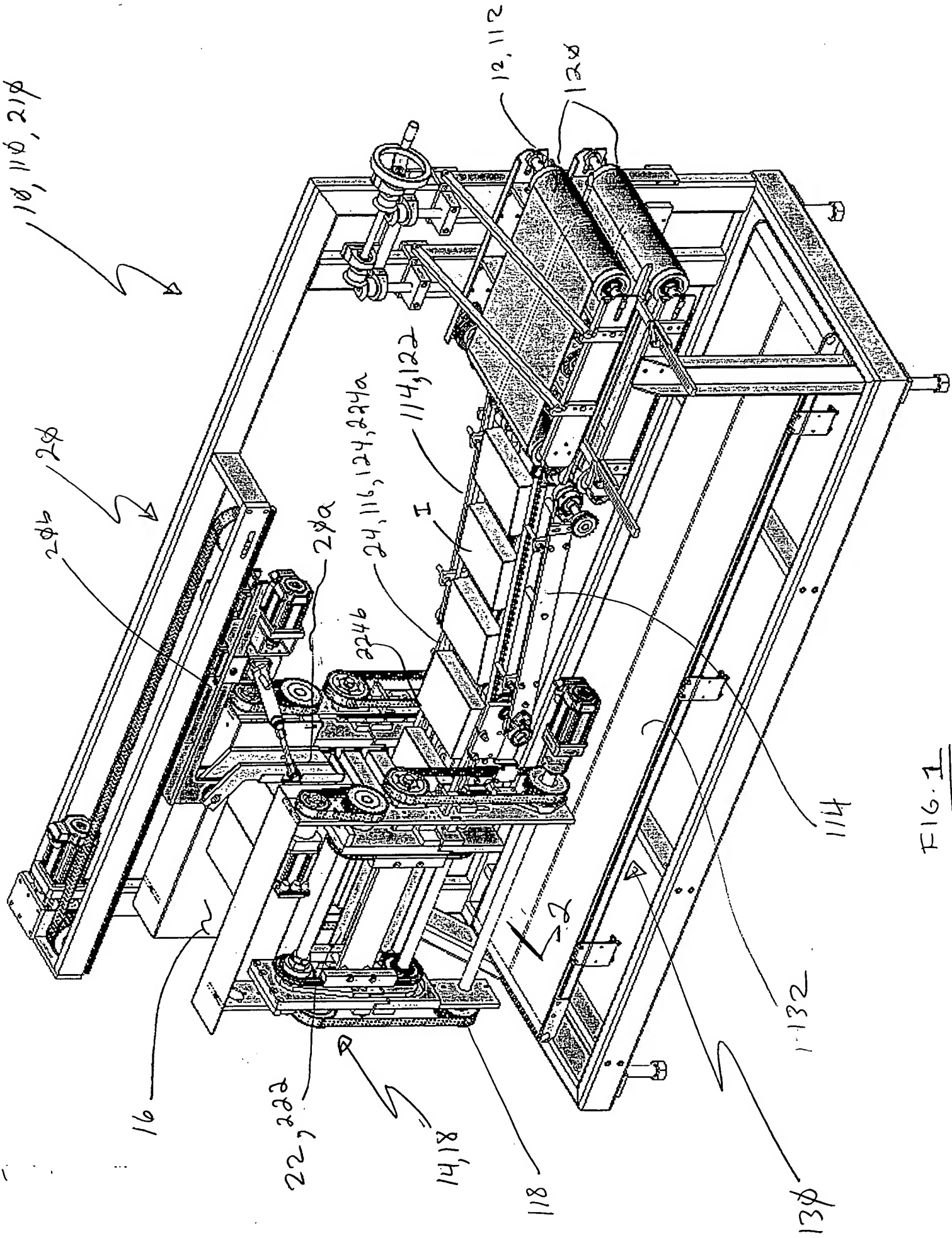
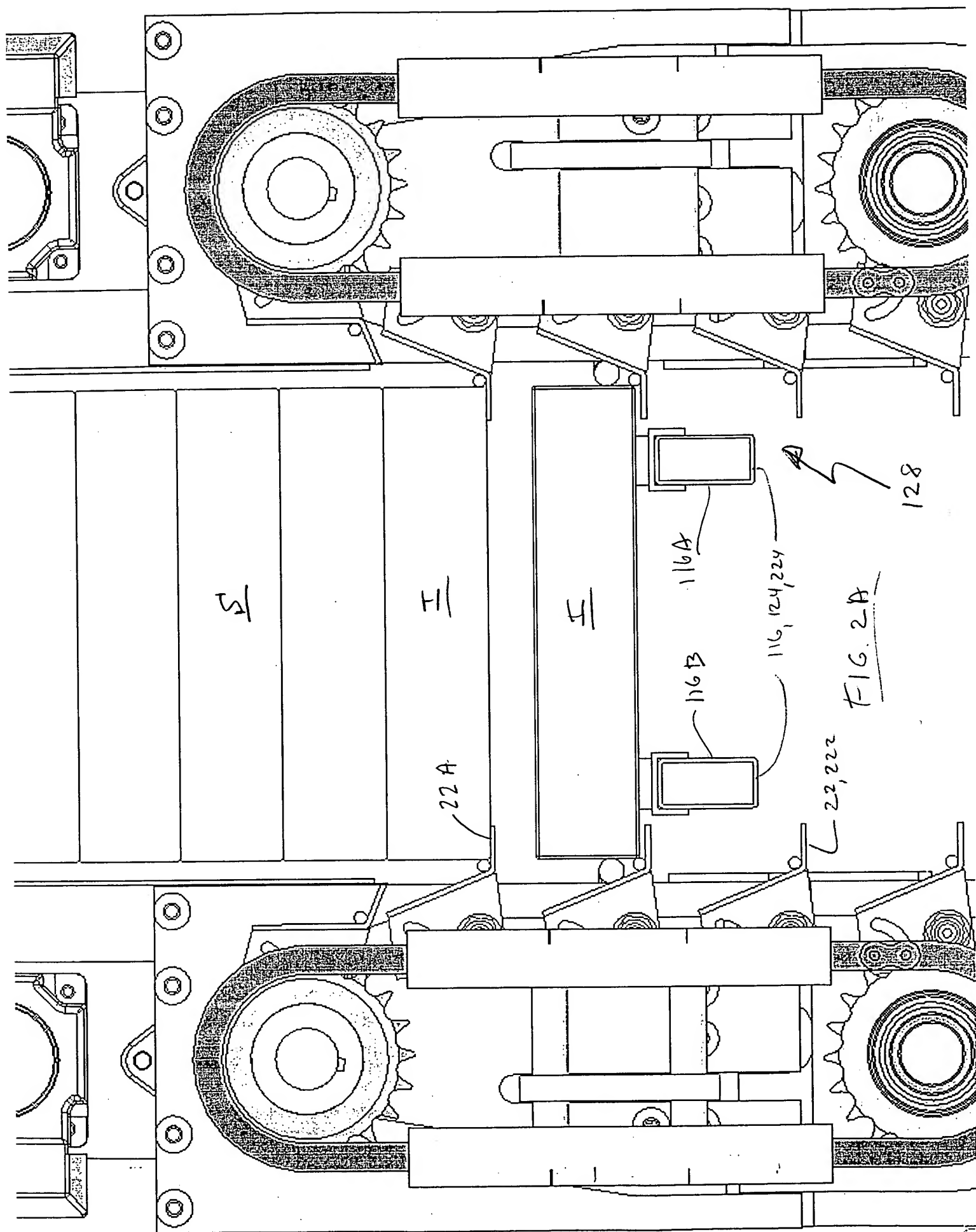
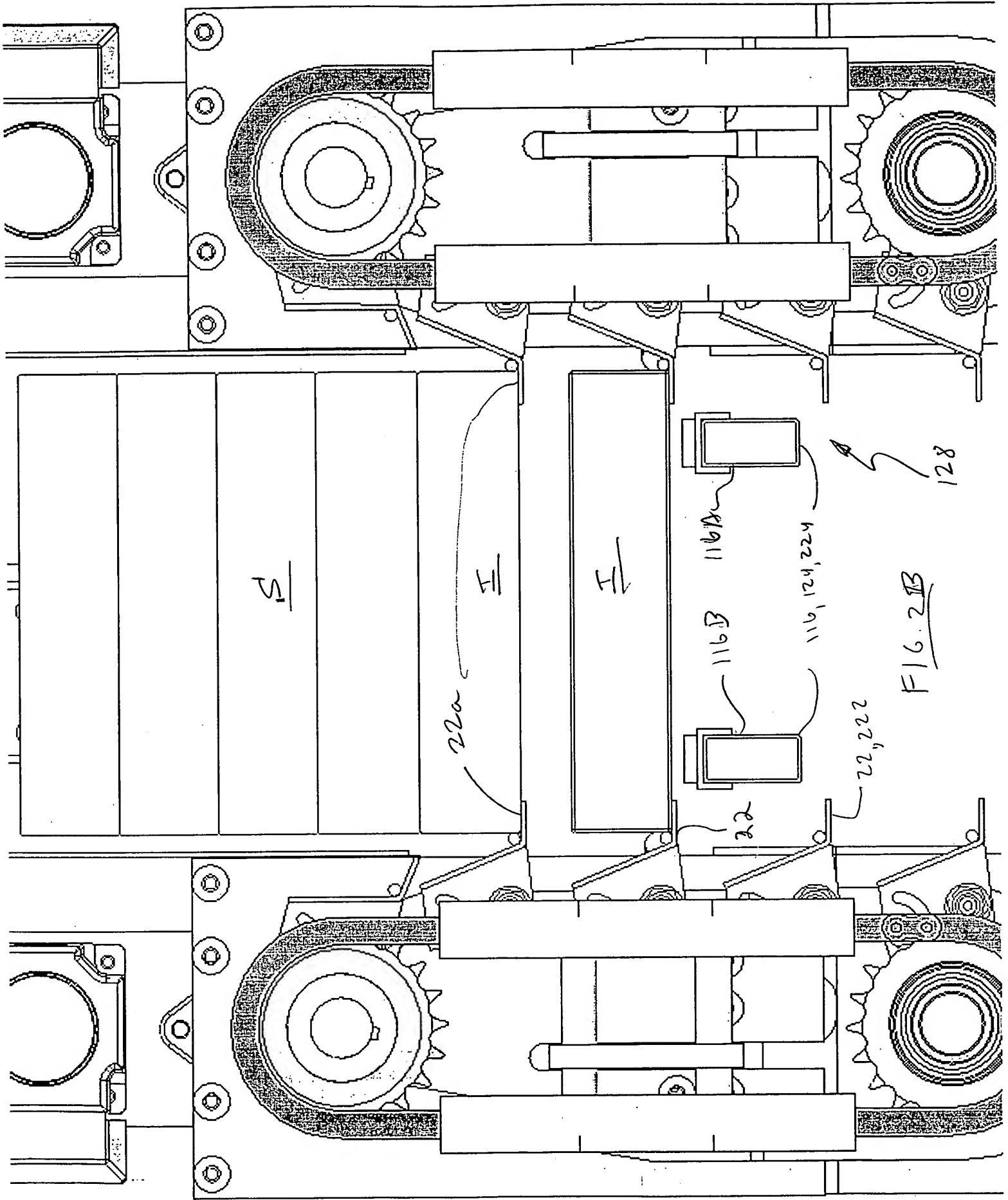


FIG. 1





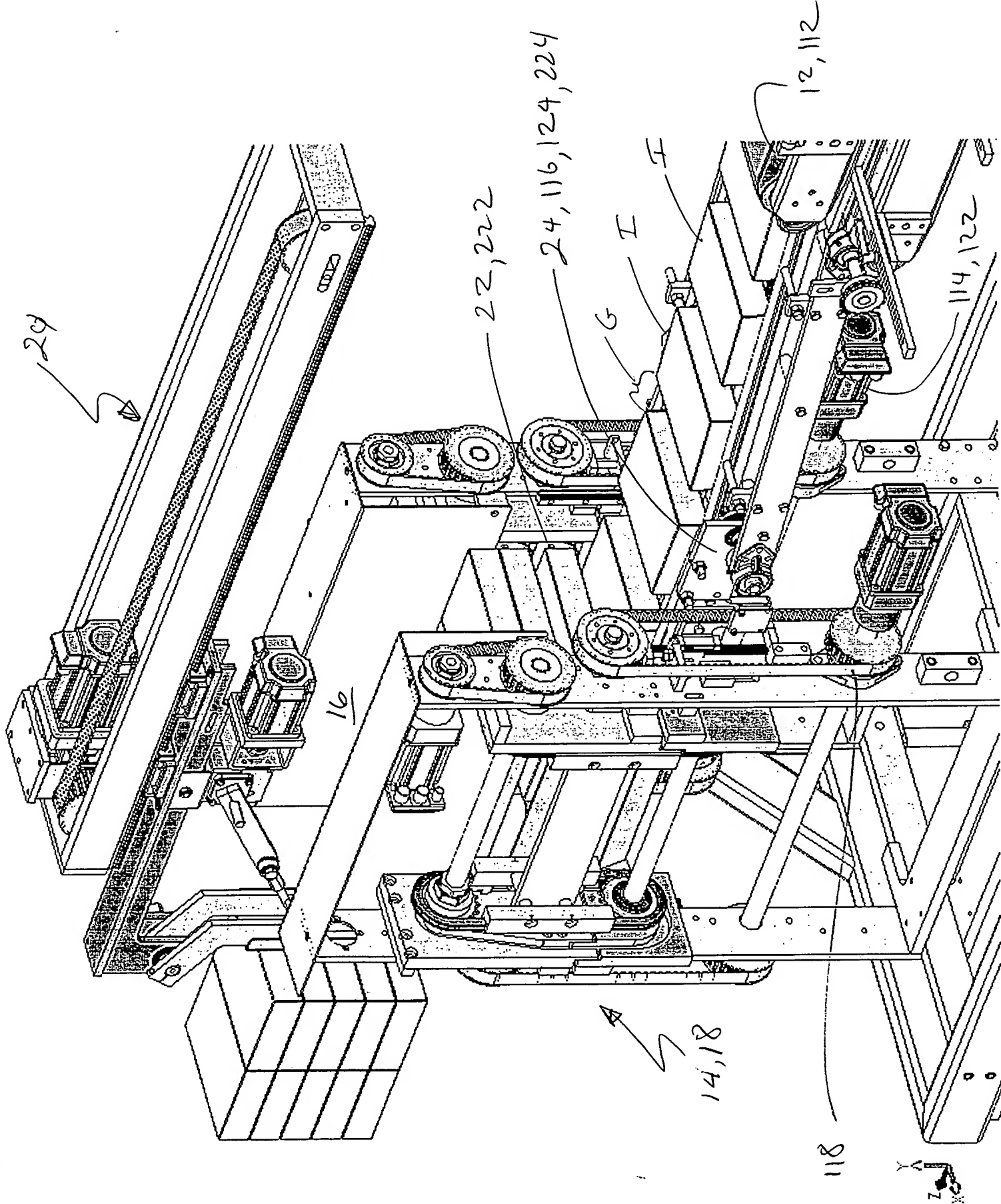


FIG. 4

(5)

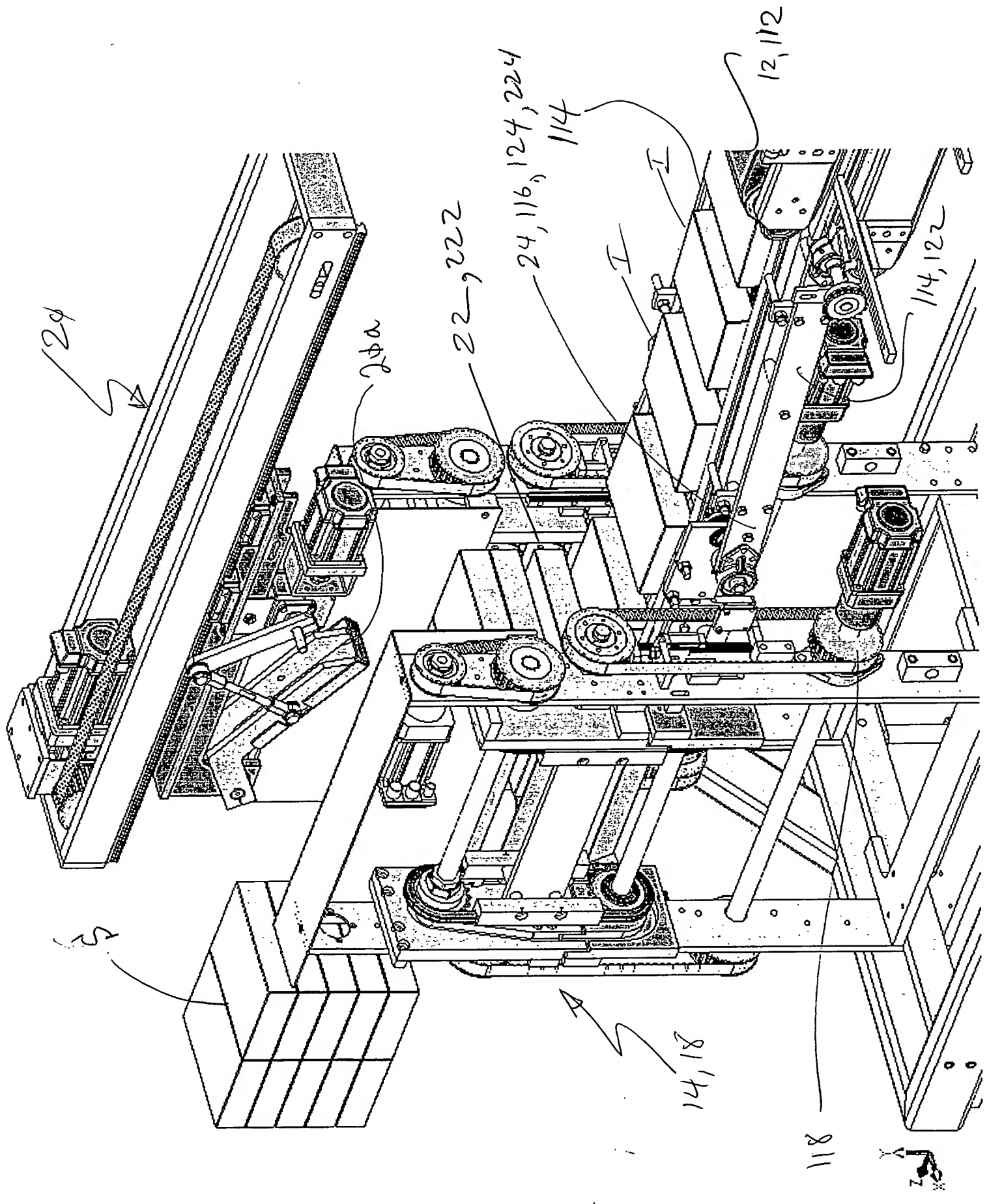
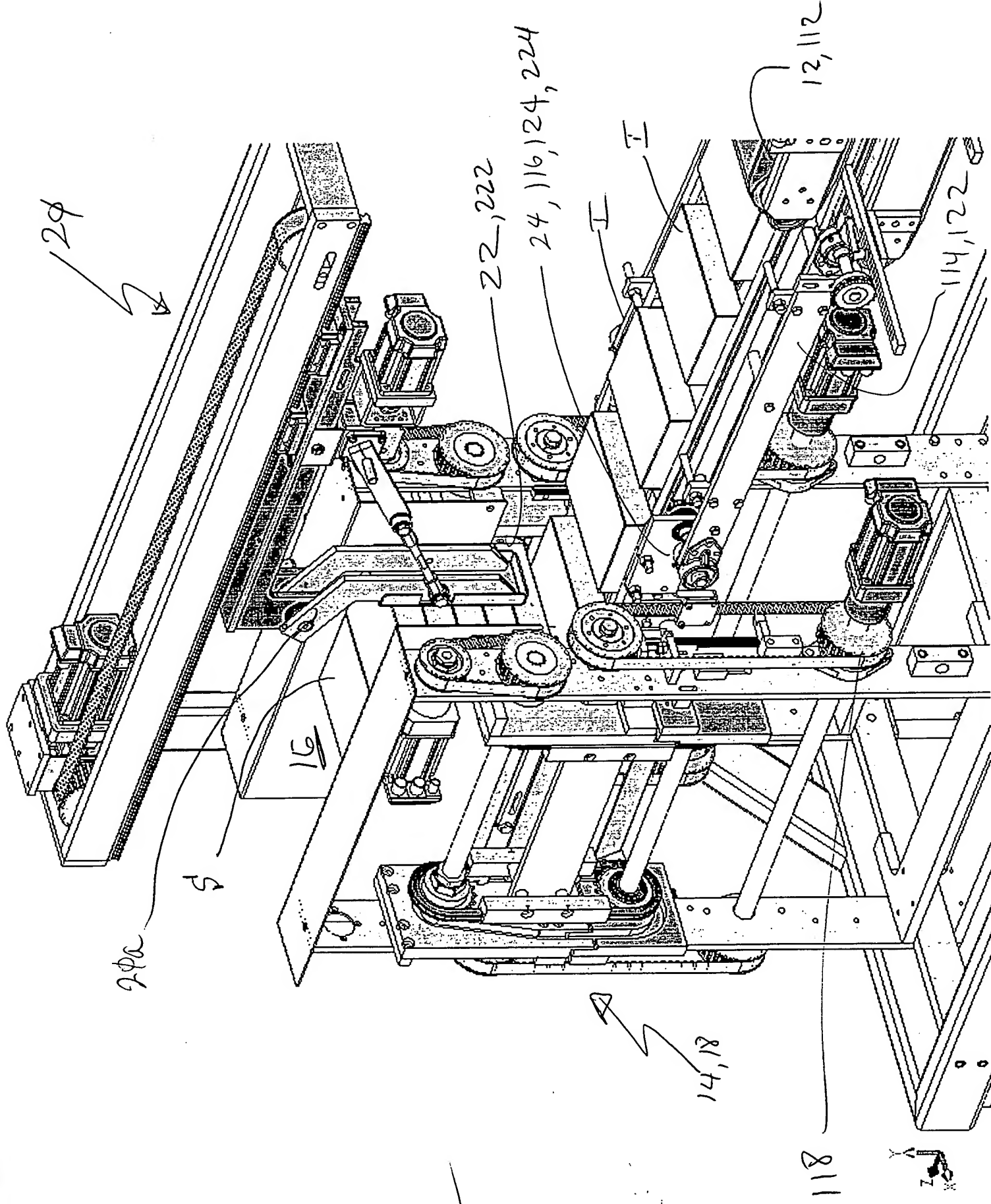


FIG. 5

FIG. 6



Stacker Conveyor Shift Control State Machine

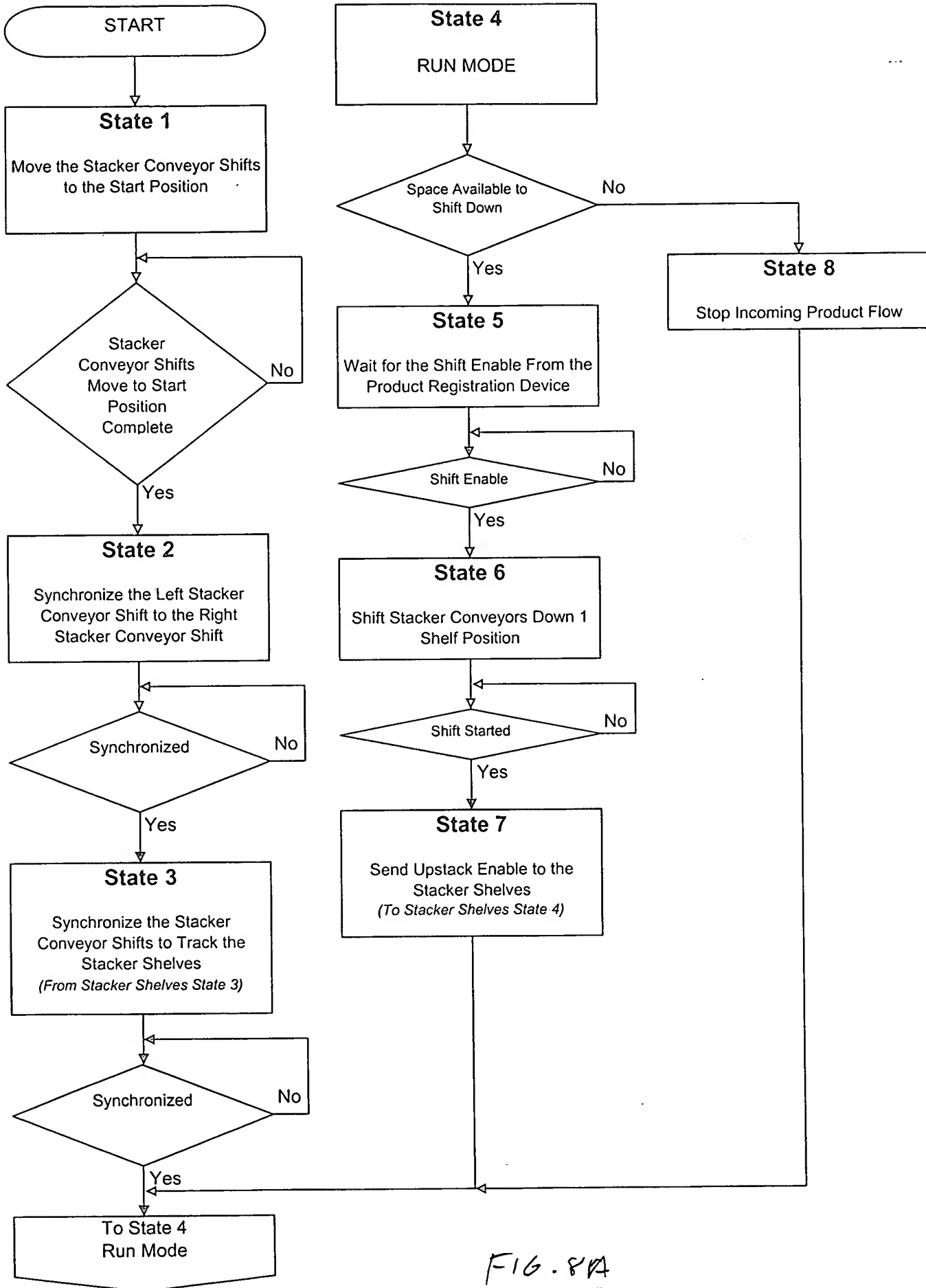


FIG. 8A

Stacker Shelves Control State Machine

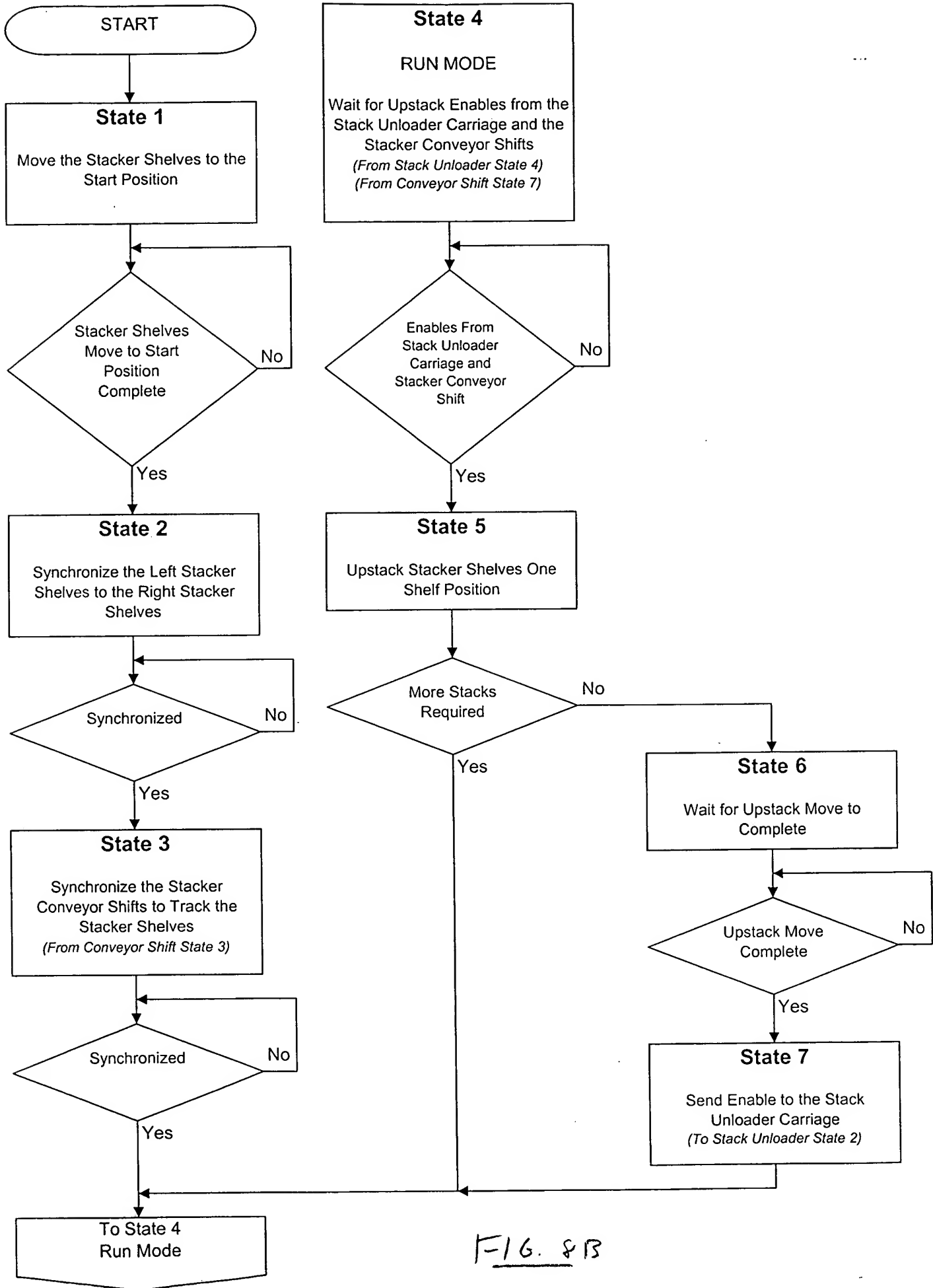


FIG. 8B

Stack Unloader Carriage and Pusher Control State Machine

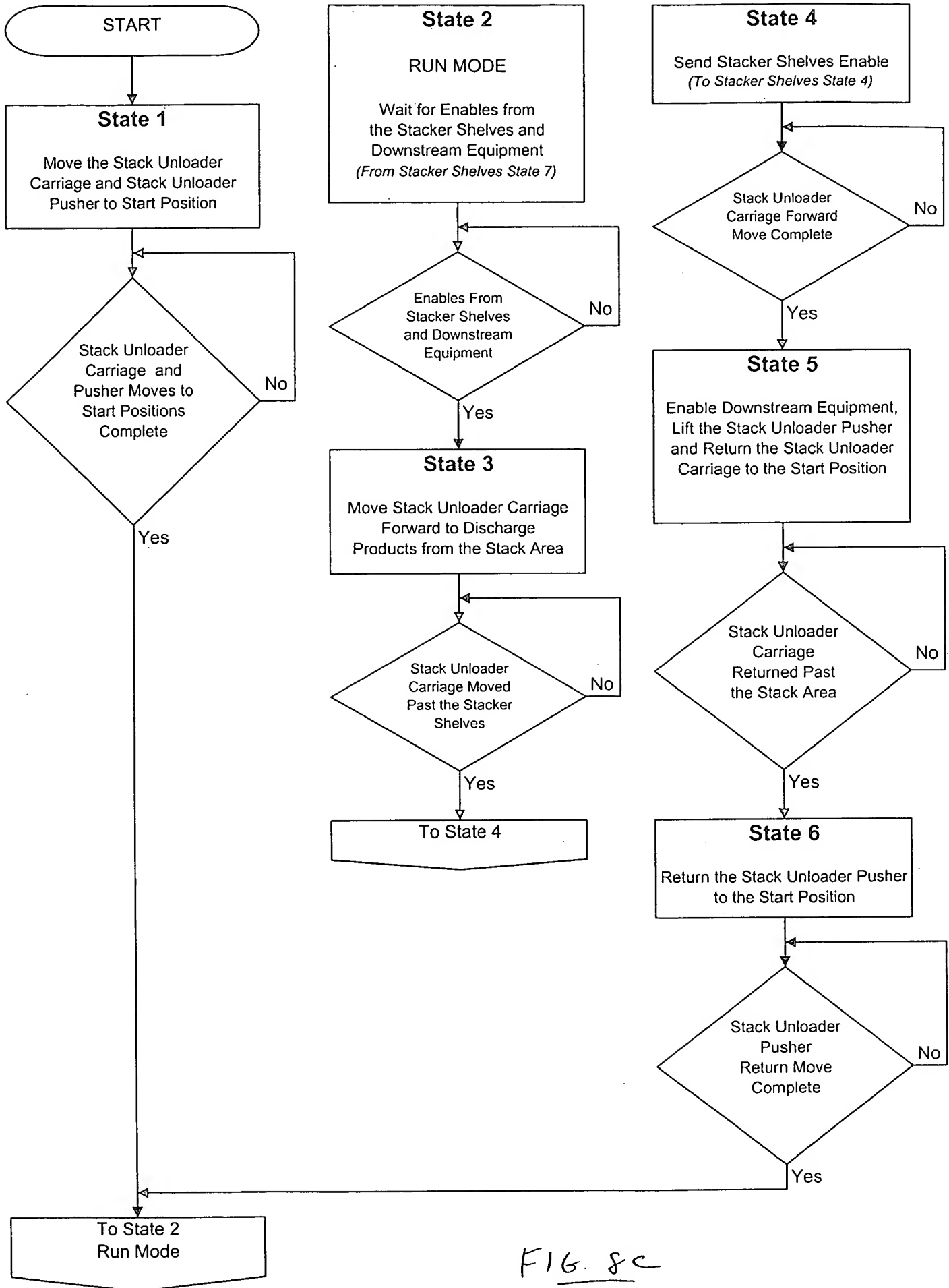


FIG. 8c

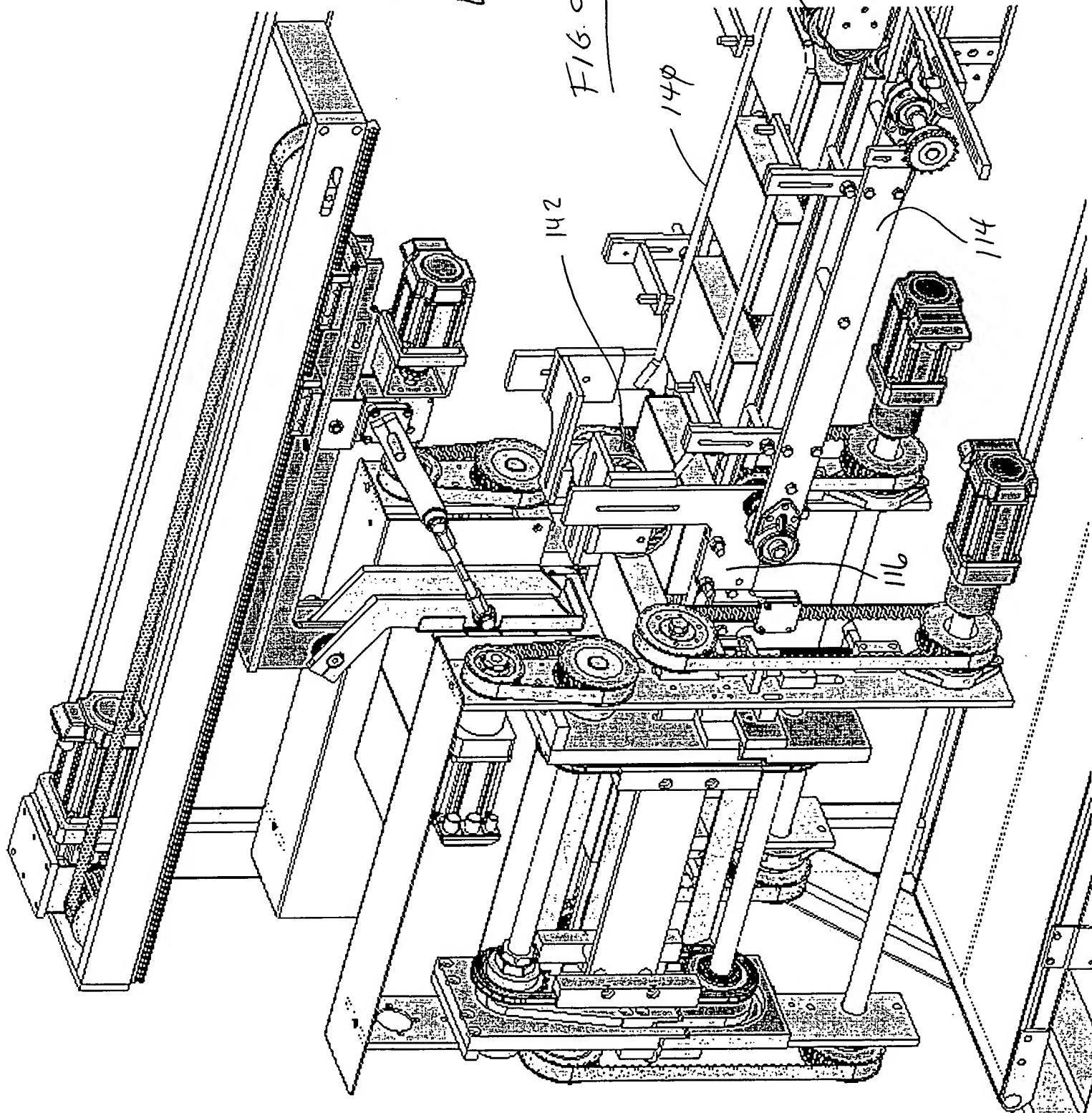


FIG. 9

72

10

22

I

II

FIG. 10

152, 152A

116

151

